: SADDLE, INBOARD, RS, 206



User:

Monday, 11/21/2005 11:53:27 AM

Linda Lacelle

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 23923

**Estimate Number** P.O. Number

: 10821 :NIA

This Issue

: 11/21/2005 S.O. No. : N/A

: NC

: NIA : NIA

Type

: MACHINED PARTS

**Drawing Number Project Number** 

**Part Number** 

**Drawing Name** 

**Drawing Revision** 

Material **Due Date**  : N/A : 12/20/2005

: D26662

: N/A

. D2666 REV. B

Qty:

16

Um: Each

Written By

Prsht Rev.

First Issue

**Previous Run** 

Checked & Approved By Comment

Removed P/O for Powder Coat - in house

processEC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0 D6101001

7075-T7351 2X6X6.25



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

12.0000 Each(s)

7075-T7351 2X6X6.25 Issue material from stock: Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: 324896

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #



Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. So alollo?

1-Inspect part number and batch number are programmed correctly. 14 06/01/09

2-Fixturing W/O No. WA

3-Fixturing Inspection last completed on block by \_\_\_\_\_\_\_

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step-No 3 of Folio and visually inspect as per attached Dimension Sheet 7- Deburr 186

06/01/14

16

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



**Comment: CONVENTIONAL MILLING MACHINE** 

Machine Keyway and inspect per attached dimension sheet

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Page 1

Form: rprocess

Dart Ae	rospace Li	td								
W/O:				WO	RK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE	CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approv QC Inspec
		v						-		
					· · · · · · · · · · · · · · · · · · ·				,	
Part No	):	PAR #:	Fau	t Categ	ory:	NCR: Yes	No DQA	: (	Date: <u>(</u>	x0/01/1
	<u> </u>					QA: N	/C Closed:	:	_ Date: _	
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK	ORDE	R NON-CONFORMAN	CE (NCF	<b>(</b> )			
DATE	STEP	Description of NC			Corrective Action Section		Verifica	ation	Approval	Approva
DATE	SIEP	Section A	Initia Chief	al ing	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspect
								:		
i										

NOTE: Date & initial all entries

Monday, 11/21/2005 11:53:27 AM Linda Lacelle User: **Process Sheet** Drawing Name: SADDLE, INBOARD, RS, 206 Customer: CU-DAR001 Dart Helicopters Services Job Number: 23923 Part Number: D26662 Job Number: Seq. #: **Machine Or Operation:** Description: SECOND CHECK 5.0 QC8 06 Comment: SECOND CHECK HAND FINISHING HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 SAD 101114 7.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT PACKAGING RESOURCE #1 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 36 DOCUMENT CONTROL 10.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Sur 06/01 Job Completion

Dart Ae	rospace	e Ltd								
W/O:				WC	ORK ORDER CHANGES			* ·* ·		
DATE	STEP	PR	OCEDURE			Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fau	t Cate	gory:NO	CR: Yes	No DQA	:	_ Date: _	<del> </del>
						QA: I	N/C Closed	:	_ Date: _	
NCR:			WORK	ORDI	ER NON-CONFORMANC	E (NCI	₹)			
		Description of NC			Corrective Action Section B		Verifica	ation	Approval	Approval
DATE	STEP	Section A	Initia Chief		Action Description Chief Eng	Sign and Date	Section Section		Chief Eng	QC Inspector
					•					
		ھ								

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	23923
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Re					
Dim	Min	Max	Go/No Go Gauge	1.	2	3	4	Ву	Date
Α	0.100	0.140		6.,25	0.124	1171	.177		
В	0.100	0.140		0-120	0.130	.170	.171		
С	0.100	0.140		0.123	6.123	170	170		
D	0.210	0.230		<u>0.270</u>	0.220	.122	1122		
E	1.245	1.255		1.247	1.248	1.750	1.750		
F	1.245	1.255		1.247	1.248	1.250	1.750		
G	5.990	6.010		6.∞3	6.002	6,001	6000		
H	0.510	0.515		0.517	0.512	0.577	0512		
i	1.674	1.684		1.678	1.678	1.678	1.678		
J	2.495	2.505		2500	2.497	7.500	7.500		
K	0.257	0.262	DT8683	0.259	0 259	0.259	0.259		
L	0.312	0.317	DT8686	Q.312	0.317	0.3/7	6.312		
M	0.235	0.240		6.238	0.238		0.238		
N	0.100	0.140		0.116	0,117	.170	.172		
0	0.540	0.560		0.545	0544	.545	.545		
P	0.490	0.510		0.447	6.497	.501	.500		
Q	3.609	3.619		3.610	3.6/2	3.612	3.611		
R	2.470	2.510		2496	2.497	7.490	7.490		
S	0.240	0.270		0.252	6.253	. 751	.157		
T	0.100	0.180		0.140	0.740	0./48	6./40		
U	0.313	0.318	DT8686	0.3/8	6.318	0.3/8	0.3/8		
V	1.125	1.145		1./30	1.131	6/3/	1.131		
W	1.565	1.585	DT8695 A/B		-				
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF				- 3.					
AG			,		-				
AH									
	Acc	ept/Reje	ct						

Measured by: Co /36	Audited by 3, 6
Date: 06.00.10	Date: 06/01114

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
С	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

DART AEROSPACE LTD	Work Order:	23923
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.170	.171	.121	.121		
В	0.100	0.140		921.121	.177	.121	.177		
С	0.100	0.140		1170	.120	.120	. 120		
D	0.210	0.230		.770	.120	.220	.770		
Е	1.245	1.255		1.750	1.750	1.750	1.250		
F	1.245	1.255		1.750	1.750	1.250	1.250		
G	5.990	6.010		6.003	6.004	6.009	6.004		
Н	0.510	0.515		0-5/2	0-5/2	0-512	0-572		
ı	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		2.500	7.500	2500	7.500		
K	0.257	0.262	DT8683	0.759	0.259	0.259	٥.253		
L	0.312	0.317	DT8686	0.312			0.3/2		
- M	0.235	0.240		0.240	0.738		0.238		
N	0.100	0.140		.170	. 170	.171	.170		
0	0.540	0.560		.547	.546	.549	1550		
Р	0.490	0.510		.498	.498	. 498	. 498		
Q	3.609	3.619		3-614	3.614	3.61-1	3.614		
R	2.470	2.510		2.490	2.490	2.490	7.490		
S	0.240	0.270		.751	. 251	. 251	1251		
T	0.100	0.180		0-148	6.140	0./40	0.140		
U	0.313	0.318	DT8686	0.3/8	0.318	0.3/8	0.3/8		
V	1.125	1.145		1.130	1.130	1.130	1.130		
W	1.565	1.585							
Х									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
	Acc	ept/Reje	ct						

Measured by:	36	1 En		Audited by	J.6		
Date:	06.01.11	06/01/14	/	Date:	06/01	14	
	,	,					•

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
С	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	

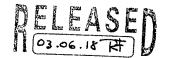
DART AEROSPACE LTD	Work Order:	28923
•		
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

	· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·		Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140	- mint Color	121	170	.121	1170		
В	0.100	0.140	المحتلف	.177	.122	.170	・1てて		
С	0.100	0.140	ستد	1170	.120	151.	. 170		
D	0.210	0.230	-220	.270	. 770	1770	.770		
Е	1.245	1.255	1-740	1.750	1.250	1.750	1.250		
F	1.245	1.255	<del>1-10</del>	1.750	1.750	1.250	1.250		
G	5.990	6.010	60001	6.004	6.004	6.004	6.004		
T	0.510	0.515		0-5/2	0.512	0.512	272-6		
ı	1.674	1.684	1-679	1.679	1.679	1.679	1.679		
J	2.495	2.505	2-500	7.500	7.500	7.500	2.500		
K	0.257	0.262	DT8683	0.259	0.259	0.2579	0.283		
L	0.312	0.317	DT8686	0.3/2	0.3/2	0.312	0.3/2		
, M	0.235	0.240		0.238	0.238	0.238	B. 238		
N	0.100	0.140		1170	. 120	. 170	.170		
0	0.540	0.560		.550	.550	.550	550		
Р	0.490	0.510		. 498	. 498	. 498	.498		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		7.490	7.490	2.440	7.490		
S	0.240	0.270		. 251	. 751	.251	. 251		
Т	0.100	0.180		0.140	0.140	0140	0.140		
U	0.313	0.318	DT8686	0.3/8	0.218	0.3/8	0.3/8		
V	1.125	1.145		1.130	1.170	1.130	1.130		
W	1.565	1.585	DT8695 A/B		_				
X									
Υ									
Z	***************************************						J		
AA			7						
AB							****		
AC			,						
AD			*						
ΑE									
AF				1				<del>-</del>	
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AH	· · · · · ·						·		
	Acc	ept/Reje	ct						

Measured by:	<b>B</b> G	1 En	Audited by	J.6.
Date:	06.01.11 /	06/01/14	Date:	06/01/04

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
С	99.11.10	Added Dim. R-T	RF .	M
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	9



DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

		· · · · · · · · · · · · · · · · · · ·		Re	corded Actu	ıal Dimensi	ons		.,
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		1121	.122	.121	.121		
В	0.100	0.140		122	. 122	.171	. (21		
С	0.100	0.140		123	.122	.127	.121		
D	0.210	0.230	,	,220	1770	.220	.220		
E	1.245	1.255		1.250	1.250	1.756	1.250		
F	1.245	1.255	·	1.250	1.250	1.250	1.750		
G	5.990	6.010		6.004	6.004	6.004	6.004		
Н	0.510	0.515		0.512	0.512	0.512	0.512		
	1.674	1.684		1.679	1.679	1.679	1.679		
J	2.495	2.505		7.500	2.500	7.500	7.500		
K	0.257	0.262	DT8683	. 259	.259	. 259	. 259		
L	0.312	0.317	DT8686	.312	.312	.312	.312		
М	0.235	0.240		0.239	0.239	0.238	0.238		
N	0.100	0.140		.170	.170	.120	.170		
0	0.540	0.560		1550	.550	. 550	.550		
Р	0.490	0.510		. ५५०	, ધવજ	. પ બબ	, ५५५		
Q	3.609	3.619		3.614	3.614	3.614	3.614		
R	2.470	2.510		7.490	2.490	7.490	7.490		• •
S	0.240	0.270		· 851	. 251	. 251	.251		
T	0.100	0.180		1140	.140	.140	.140		
C	0.313	0.318	DT8686	.318	.318	.318	.318		
V	1.125	1.145		1.130	1.130	1.130	1.130		
W	1.565	1.585	DT8695 A/B			<u> </u>			
X						,			
Y									
Z									
AA									
AB							,		
AC							6		
AD									
AE	,								
AF				1					
AG									
AH									
	Acc	ept/Reje	ct						

Measured by: 36	180	Audited by 5.6
Date: 06.01.1	1/06/01/14	Date: 06/01/64

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
С	99.11.10	Added Dim. R-T	RF	И
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	9



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### Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Nov 08, 2005

10:44 am

Work Order No : 0023923

Project Name : D2666-2 Project For : WK535

Burden Flags : NNNNNNN WO Status : Open

Work Order Type : Main Invoice State : Not Invoiced

Main WO Number

House Part Number : D2666-2 Invoice Date Description : Saddle, RH, Fwd, Aft, In

Department Code:

Manufactured : Yes

Invoice Number: Invoice Amount : 0.00

Amount Req'd : Amount Done :

12.

Order Entry No :

Start Date

0 : 08-02-05 OE Value

0.00

Est Finish Date : 08-31-05

Est Margin : 0.000%

Act Finish Date Drawings Reqd

: No

Actual Margin :

0.000%

Ok for Approval : Approval Rec'd :

\$0 Posted to Finished Goods

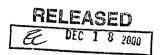
		Estimated	Actual	Var. %	Posted	To Post
Material Cost Engineering Hours	:	0.00 0.00	0.00	0.00	0.00	0.00
Engineering Cost Production Hours	:	0.00	0.00	0.00	0.00	0.00
Production Cost Packaging Hours	:	0.00	0.00	0.00	0.00	0.00
Packaging Cost OverHead Hours	:	0.00	0.00	0.00	0.00	0.00
OverHead Cost CNC Hours	:	0.00	0.00	0.00	0.00	0.00
CNC Misc. Hours	;	0.00	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00	0.00
Burden	:	0.00	0.00	0.00		
Total Cost Margin	:	0.00	0.00	0.00		
Selling Cost	:	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done 0.00 0.00 Profits/(Loss) 0.00 0.00

DART AEROSPACE LTD.	Work Order :	23923
		<u> </u>
Description: 206 Saddle, Inboard, Right Side	Part Number:	D2666-2
Drawing: D2666 Rev. B	Qty:	12,16

STORES   Issue Mork Order   Issue Mork Order   Issue Mork Order   Issue material from stock: 7075-T7351   Cut Size 2.0 x 6.25 x 6.0 Grain Along Long 6.0 Length (Decir-or) RF exhorits   Batch No: BZY890   Endology   Store of the correctly   Issue material from stock: 7075-T7351   Cut Size 2.0 x 6.25 x 6.0 Grain Along Long 6.0 Length (Decir-or) RF exhorits   Batch No: BZY890   Endology   Iz   Iz   Iz   Iz   Iz   Iz   Iz   I	Step	Location	Procedure	Ву	Date	Qty
2 STORES Issue material from stock: 7075-17351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length (Decension) RF ox long IIB Batch No: 324850  3 HAAS Program part number and batch number.  4 QC Inspect part number and batch number are programmed correctly.  5 HAAS Fixturing W/O No. 1/4 Fixturing Inspection last completed ox/o1/0.9 by So. oxfolio 1.2  6 HAAS Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  7 HAAS Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  8 HAAS Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  9 LAGUN Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  10 METAL Deburr  11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  46 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order	1	EXPEDITING				
Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length  (Decol-col) Recologic Batch No: BZY850  A HAAS Program part number and batch number.  Inspect part number and batch number are programmed correctly.  Inspect part number and batch number are programmed correctly.  HAAS Fixturing W/O No.			Dwg. not required RF ocloglib	Α,	77-70	
Batch No: BZY889   September	2	STORES				
AAS			Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length			
A   QC   Inspect part number and batch number are programmed correctly.   Ms   colonida   12		ļ	(DG101-001) RF 02/09/16 Batch No: BZY890	in	060/bs	12
Inspect part number and batch number are programmed correctly.   Inspect correctly.   Inspe	3	HAAS	Program part number and batch number.			
Inspect part number and batch number are programmed correctly.   Section   Inspect correctly.   Section   Inspect				cn cn	06/01/0	912
Fixturing W/O No. Pixturing W/O No. Pixturing Inspection last completed off of 9 by Sa Salution 12 Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  7 HAAS Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  8 HAAS Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  9 LAGUN Machine Keyway and inspect per attached dimension sheet  10 METAL Deburr  11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  Acid etch and Alodine as per QSI 005 4.1  Acid etch and Alodine as per QSI 005 4.3  15 QC Inspect Level 3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  METAL Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	4	QC	Inspect part number and batch number are programmed	1		
Fixturing W/O No				MS	06/01/8	12
Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Keyway and inspect per attached dimension sheet  Machine Keyway and inspect per attached dimension sheet  Metal  Deburr  Deburr  Metal  Deburr  Metal  Acid etch and Alodine as per QSI 005 4.1  Acid etch and Alodine as per QSI 005 4.1  Acid etch and Alodine as per QSI 005 4.1  FINISHING  Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  Cocolly 12  Inspect Level 3  Metal  Stores  Pack in foam, identify and stock.	5	HAAS				
Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio And visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio And visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio And visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio And visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio And visually inspect as per attached dimension Sheet  Machine Step No 3 of Folio And visually inspect as per attached dimension Sheet  Machine Step No 3 of			Fixturing Inspection last completed of old by	5	04010	12
attached Dimension Sheet  Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Keyway and inspect per attached dimension sheet  Machine Keyway and inspect per attached dimension sheet  Deburr  Inspect Level 1  Codollar 12  Codollar 12  Acid etch and Alodine as per QSI 005 4.1  Acid etch and Alodine as per QSI 005 4.1  FINISHING  Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  Codollar 12  Codollar 12  Acid etch and Alodine as per QSI 005 4.1  SAD Sept Mr.  Codollar 12  Acid etch and Alodine as per QSI 005 4.1  SAD Sept Mr.  Codollar 12  Codol	6	HAAS	Machine Step No 1 of Folio and visually inspect as per		,	
Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet  Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  Machine Keyway and inspect per attached dimension sheet  Mac			attached Dimension Sheet	,	66/01	1012
State   Stat	7	HAAS	Machine Step No 2 of Folio and visually inspect as per	60 -		' / ' ' ' ' '
Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet  9 LAGUN Machine Keyway and inspect per attached dimension sheet  10 METAL Deburr  11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.					06/m/	12
attached Dimension Sheet  9 LAGUN Machine Keyway and inspect per attached dimension sheet  10 METAL Deburr  11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.	8	HAAS	Machine Step No 3 of Folio and visually inspect as per	50/		
METAL Deburr  Deburr  Inspect Level 1  Deburr  Deburr  Deburr  Inspect Level 1  Deburr  Deburr			attached Dimension Sheet	V	06/01/10	12
10 METAL Deburr  11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.	9	LAGUN	Machine Keyway and inspect per attached dimension sheet			
10 METAL Deburr  11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order				En	ododo	1/2
11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.	10	METAL	Deburr	50 /		
11 QC Inspect Level 1  12 QC Inspect Level 8  13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.					660ilis	, 12
13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order	11	QC	Inspect Level 1		1	
13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order				20	06/01/10	12
13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order	12	QC	Inspect Level 8		OGOLIER	
13 METAL Acid etch and Alodine as per QSI 005 4.1  14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3  15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order		·		D.G	06/01/1	1 12
14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3 FC C6 0117 1.2  15 QC Inspect Level 3 M 6 11 12  16 STORES Pack in foam, identify and stock.	13	METAL	Acid etch and Alodine as per QSI 005 4.1			
14 FINISHING Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3 FC COUNTY  15 QC Inspect Level 3 M BAIT IV  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order		ļ	<u>'</u> .	SAO	06 /01 /H	$r_{-}$
15 QC Inspect Level 3  16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order	14	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	-0	<del>  ' </del>	
16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order			, , , , , , , , , , , , , , , , , , , ,	1/	06011	12
16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order	15	QC	Inspect Level 3	11	<b> </b>	.1
16 STORES Pack in foam, identify and stock.  17 EXPEDITING Close Work Order				1111	2111	10
17 EXPEDITING Close Work Order	16	STORES	Pack in foam, identify and stock.	<del>                                      </del>	<del>V V' '  </del>	<del>'</del>
			,,			
	17	EXPEDITING	Close Work Order			
		<del>-</del>	Job Cost / Part			]

Rev	Date	Change	Created By	Approved
Α	97.07.24	New Issue		***
В	98.09.08	Inspection levels, added powder coat	KS	
С	00.11.01	Removed P/O for Powder Coat – in house process	EC	fr.



# **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CH	ANGES	3				
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
NCR:			WORK ORDE	R NON-CONFO	RMAN	CE (NCR	2)			
		Description of NC		Corrective Action			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Descrip Design Mgr		Sign 8 Date		ion C	Design Mgr	QC Inspector
					1					
								<del></del>		. ¥
Part No	):	PAR #:	Fault Category	:	NCR:	Yes No	DQA:		Date:	· 1
NOTE: D	ate & initial	all entries				QA: N/C CI	osed:		Date:	





DESIG	grøy	DRAWN BY	DART AEROSPACE USA, INC.
CHEC	KED /	APPROYED	DRAWING NO. REV. B
	grus	8	D2666 SHEET 1 OF 1
DATE			TITLE SCALE
97.0	77.11		SADDLE FWD INSIDE HIGH 2:5
Α		97.03.25	NEW ISSUE
В		97.07.11	ANGLE AND NOTES ADDED

0.063

R0.50

0.110

SECTION A-A

R1.245

R1.135

0.250

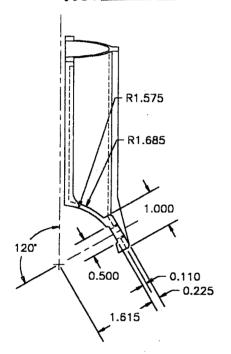
**EFFECTIVE DEOs** 4095 9122 97/11/06 DS 9102 98/05/04 0.050 x 45 CHAMFER (TYP)

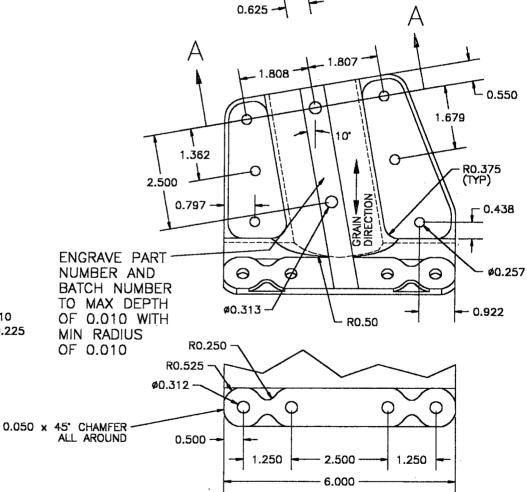
RETURN TO **ENGINEERING** 

**UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE

## **WORK ORDER**

NO. 23923





197/07/16 ECN 008

0

# CPOO.OSAS

MATERIAL: 7075 T651 OR 7075-T7351 (QQ-A-250/12)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
PRIME, PAINT (EXCEPT BORES) PER DART QSI 005 4.2

NOTE: D2666-1 SHOWN (D2666-2 IS OPPOSITE)

BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### 

### Job Costing Report

Dart Aerospace Ltd.

Hawkesbury

Aug 02, 2005 01:38 pm

Work Order No : 0023923

Project Name : D2666-2

Project For : WK535 Work Order Type : Main

Main WO Number :

House Part Number : D2666-2

Description : Saddle, RH, Fwd, Aft, In Manufactured : Yes

Amount Req'd: 12
Amount Done: 0

Start Date : 08-02-05

Est Finish Date : 08-31-05

Act Finish Date :
Drawings Reqd : No
Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN
WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number:

Invoice Amount: 0.00

Order Entry No :

: OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

Estimated Actual Var. % Posted To Po	
Material Cost : 0.00 0.00 0.00 0.00 0.00 0.	.00
Engineering Hours: 0.00 0.00 0.00	
Engineering Cost : 0.00 0.00 0.00 0.00 0.00	.00
Production Hours: 0.00 0.00 0.00	
Production Cost : 0.00 0.00 0.00 0.00 0.00	.00
Packaging Hours : 0.00 0.00 0.00	
Packaging Cost : 0.00 0.00 0.00 0.00 0.00	.00
OverHead Hours : 0.00 0.00 0.00	
OverHead Cost : 0.00 0.00 0.00 0.00 0.	.00
CNC Hours : 0.00 0.00 0.00	
CNC : 0.00 0.00 0.00 0.00 0.	.00
Misc. Hours : 0.00 0.00 0.00	
Misc. : 0.00 0.00 0.00 0.00 0.	.00
Burden : 0.00 0.00 0.00	
Total Cost : 0.00 0.00 0.00	
Margin : 0.000 0.000	
Selling Cost : 0.00 0.00	

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) : 0.00 0.00